

Page 1

Thursday, June	23, 2011 11:0	07:09 AM								
Item ID: Revision ID:	D3504-1			Accept					Setup Sta	rt
Item Name:	Crossbolt Spa	cer						•	Sto	р
	6/23/2011	Start Qty: 20.00			Cust Item I	D.				
Required Date:		Req'd Qty: 20.00			Cust item i	υ;				
Reference:				1	Customer.					
Approvals:	Process Pla	in: CL	Date: \ \ 06\ \ 3	Tooling:	Da	ate:			Run Stai	
	QC:			SPC (Y/N):	Da	ate:			Sto	
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Insp. Number Stamp
Draw Nbr	Rev	ision Nbr								
D3504	Rev	C								
100 Hardinge		Hardinge CNC LATHE	SMALL	0.00				25	- b	
Hardinge CNC Lath	e Small	FOLIO REV DWG REV:	S PER FOLIO FA642 & DW V: : : AS REQUIRED		11)7/6					,
		QC2- Inspect parts off m	nachine FAI/FAIB	0.00			•	25	b	, <u></u>
QC Quality Control		Memo	<	5000	17/6				-	
120		QC8- Inspect parts - seco	ond check	0.00	11.7.	6		25		^
QC Quality Control		Memo		0.00				<u></u> .	· · · <i>C</i> - · · ·	

Dart Aerospace L	.td	
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	•								
W/O:			W	ORK ORDER CHANG	GES				
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
				•			_		
				,					
Part No	:	PAR #:	Fault Cat	egory:	NCR: Yes	No DQ	A:	Date: _	
	R	esolution:	Dispositi	on:	QA: N/C C	osed:		Date: _	
NCR:			WORK OR	DER NON-CONFORM	ANCE (NCF	R)			
DATE	STEP	Description of NC			tion B	Verific	cation	Approval	Approval
DAIL	O.L.	Section A	Initial Chief Eng	Action Description Chief Eng	Sign a		on C	Chief Eng	QC Inspector
		·							
·									
	1		1 1		1	I		I	1

NOTE: Date & initial all entries

Work Order ID 71130

Thursday, June 23, 2011 11:07:09 AM



Page 2

Item ID:

D3504-1

Accept

Setup Start

Stop

Revision ID:

Item Name: **Start Date:**

Crossbolt Spacer

6/23/2011

Start Qty: 20.00

Req'd Qty: 20.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



Required Date: 6/29/2011

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID

130

Packaging

Packaging

Operation Description

Identify as per dwg & Stock Location

Memo

Memo

Set Up/ **Run Hours**

0.00

0.00

Tool ID

Tool # Plan

Accept Qty Code

Reject Qty

Reject Number

Insp. Stamp

140

QC21- Final Inspection - Work Order Release

0.00



Quality Control

STOCK IN SKIDTUBE CELL

0.00

M/1/20 DX MC11-07-19

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	•								
W/O:			W	ORK ORDER CHANG	ES				·
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
								l:	
Part No	:	PAR #:	Fault Cate	egory:	_ NCR: Yes	No DQ	A:	_ Date: _	
	Re	esolution:	Disposition	on:	_ QA: N/C C	closed:		Date: _	
NCR:		,	WORK ORD	ER NON-CONFORMA	NCE (NC	R)			
DATE	STEP	Description of NC		Corrective Action Section		Verific	cation	Approval	Approval
	0.2.	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	Section Section	ion C	Chief Eng	QC Inspector
							٠		·
									·
		·							

NOTE: Date & initial all entries

Picklist Print

Thursday, June 23, 2011 11:07:06 AM

Work Order ID: 71130

Parent Item:

D3504-1

Parent Item Name: Crossbolt Spacer



Start Date: 6/23/2011

Required Date: 6/29/2011

Start Qty: 20.00

Required Qty: 20.00

Comments:

IPP Rev:A New Issue 06-06-20 JLM

IPP Rev:B Rev C dwg 07-12-06 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Status Issued	
M6061T6T0.500W.049		Purchased	No			100	f	327.3512	0. 2 83	5.957895	5	. 1111	
										21	7	11/1/4	

6061-T6 RD Tube .500 x.049W

Loc Code Loc Qty Location 327.351211 327.351211

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W/O:			WO	RK ORDER CHANG	BES				
DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
							:		
		,							
Part No	•	PAR #:	Fault Categ	ory:	NCR: Yes	No DQ	A:	Date: _	·
	Re	solution:	Disposition	:	_ QA: N/C (closed:		Date: _	· · · · · ·
NCR:		\(\frac{1}{2}\),	WORK ORDE	R NON-CONFORM	ANCE (NC	R)	-		
DATE	STEP	Description of NC			tion B	Verifi	cation	Approval	Approval
	J.L.	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date		ion C	Chief Eng	QC Inspector
			·						
				•					

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	7/130
Description: Cross Bolt Spacer	Part Number:	D3504-1

Inspection Dwg: D3504 Rev: C		Page 1 of 1

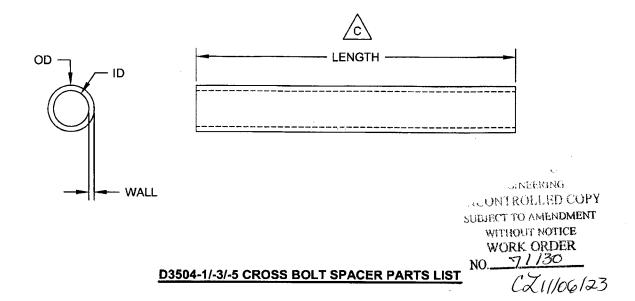
FIRST ARTICLE INSPECTION CHECKLIST

X First A	rticle	Prototype
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Drawing	Tolerance	Actual	Accept	Reject	Method of	Comments
Dimension	Tolerance	Dimension	Accept	Reject	Inspection	Comments
Ø0.500	+0.006/-0.001	0.500			RNG	
0.049	+/-0.010	.045			1	
3.475	+0.030/-0.000	3.490				
Ø0.402	+0.006/-0.001	9,407				
						¨

Measured by:		Audited by:	R	Prototype Approval:	N/A
Date:	11/7/6	Date:	11.7.6	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	06.10.03	New Issue	KJ/JLM	
В	06.12.14	• •	KJ/JLM , ,	
С	08.01.16	Dwg Rev updated	KJ/EC/DD	N/



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/c\

PART NUMBER	OD	WALL	+0.030 -0.000	ID	MATERIAL SPEC	NOTE
D3504-1	0.500	0.049	3.475	0.402 (REF)	M6061T6T0.500W.049	SEE NOTE 1a)
D3504-3	0.375	0.049	3.475	0.277 (REF)	M6061T6T0.375W.049	SEE NOTE 1a)
D3504-5	0.750	0.080 (REF)	3.400	0.590	M6061T6R0.750	SEE NOTE 1b)

D3504-1/-3/-5 CROSS BOLT SPACER:

1) MATERIAL: a) 6061-T6 OR 6061-T62 TUBING

PER WW-T-700/6 OR AMS 4080 OR AMS 4082

OR QQ-A-200/8 OR QQ-A-225/8

(REF. DART SPEC, M6061T6TD.DDDW.TTT)

b) 6061-T6 (OR 6061-T651/T6510/T6511/T62) ROUND BAR

PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR

PER AMS-QQ-A-200/8 (OR AMS 4160)

(REF. DART SPEC. M6061T6R0.750)

- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A



·C	ADD -5		DC	07.09.19			
В	3.475 V	VAS 3.400	PH	06.11.01			
Α	NEW IS	SSUE	PH	06.04.21			
REV.			BY	DATE			
DESIGN		PH	DART AEROSPACE LTD				
DRAWN DC		DC	HAWKESBURY, ONTARIO, CANADA				
CHECKED		PH	DRAWING NO.		REV. C		
MFG. APPR.		20	D3504	SHEET 1 OF 1			
APPROVED		M	TITLE		SCALE		
DE APPR.		A	CROSS BOLT SPACER				
DATE	07.0	9.19	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WAITTEN PERMISSION FROM DATA LARGISPACE LTD.				